

D206-559-613

DONE

Work Order ID 67171



Page 1

Wednesday, March 09, 2011 12:54:07 PM

Item ID: D2432

Accept



Setup Start



Revision ID:

Stop



Item Name: 206 (24") Bearpaw

Start Date: 3/9/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 3/16/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan: *H*

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2432

Rev F3

120

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D2432 File

B11-3-10

(8)

130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
 2-Machine as per Folio and Dwg D2432 Identify as D2432F
 3-Deburr

SL 11/03/22

(8)

140

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 11/03/22

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 67171

Page 2

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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC8- Inspect parts - second check

0.00

B.A 11/03/22

8

0

QC

Memo

0.00

Quality Control

151



Identify as per dwg & Stock Location:

0.00

Packaging

Memo

0.00

Packaging

C 4/3/22 (S)

190



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/3/22 (S)

C 2 11/03/22

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Picklist Print

Wednesday, March 09, 2011 12:54:13 PM

Page 1

Work Order ID: 67171

Parent Item: D2432

Parent Item Name: 206 (24") Bearpaw




Start Date: 3/9/2011

Required Date: 3/16/2011

Start Qty: 8.00

Required Qty: 8.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10  UHMW 1" Black		Purchased	No			120	sf	352.1000	3.7	29.6			



B11-3-10

Location

Loc Qty

Loc Code

MAT		352.1	
	115955	38.8	
	116554	108.3	
	116796	12	
	116797	193	

116797

8

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DART AEROSPACE LTD		Work Order:	67171
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432 Rev: F3		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.063 x 45°	/		vern SL-3	
B	5.500	+/-0.030	5.505	/		"	
C	0.200	+/-0.030	.195	/		"	
D	0.25 x 45°	+/-0.030	0.250 x 45°	/		"	
E	R0.250	+/-0.030	.250	/		R-G	
F	0.250	+/-0.010	.250	/		"	
G	0.625	+/-0.030	.620	/		"	
H	0.375	+/-0.010	.377	/		"	
I	0.950	+0.030/0.010	.950	/		"	
J	19.000	+/-0.030	19.00	/		m-type	
K	3.14	+/-0.030	3.150	/		"	
L	3.28	+/-0.030	3.290	/		"	
M	Ø0.260	+0.005/-0.000	.260	/		"	
N	Ø0.93	+/-0.030	.925	/		"	
O	0.30	+0.030/-0.000	.315	/		"	
P	23.750	+/-0.030	23.750	/		m-type	
Q	7.375	+/-0.030	7.377	/		vern circ-02	
R	4.250	+/-0.010	4.250	/		"	
S	2.000	+/-0.030	2.000	/		"	
T	9.000	+/-0.010	9.00	/		"	
U	9.000	+/-0.010	9.00	/		"	
V	0.375	+/-0.010	.378	/		"	

Measured by:	SL	Audited by:	B.A	Prototype Approval:	N/A
Date:	11/03/17	Date:	11/03/22	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O K10008/D206-559-015	KJ/RF	JF

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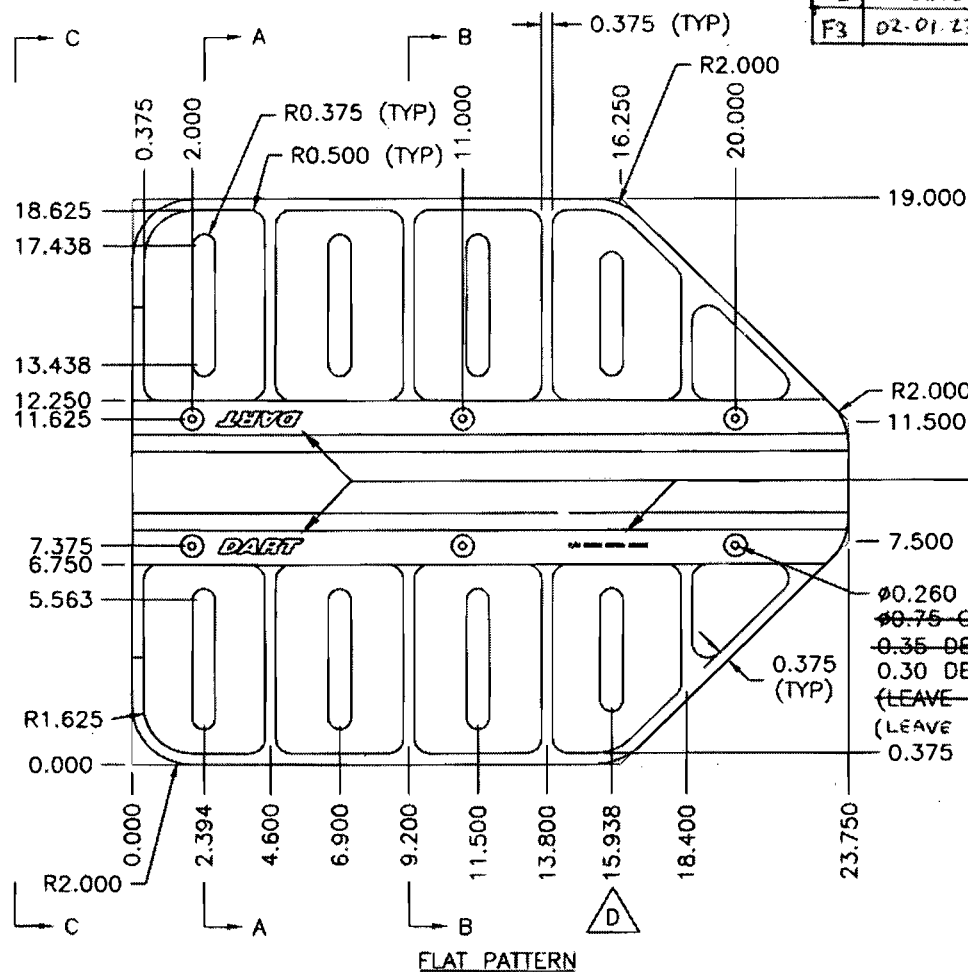
NOTE: Date & initial all entries

Copyright 1995 by DART AEROSPACE LTD

F1	99.03.03	ADD DEO 9143
F2	01.03.28	00.93 WAS 00.75 RF
F3	02-01-23	CLARIFY CORE DIMS RF

93.06.17 KE

DART



ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 4717

~~00.260 (TYP)~~
~~00.75 C'BORE~~ 00.73 C'BORE
~~0.35 DEEP FROM TOP (MIN.)~~
 0.30 DEEP FROM BOTTOM
~~(LEAVE 0.300 MIN.)~~
 (LEAVE 0.650 MIN.)

FI 11-03-9

EFFECTIVE DEOS

9143

D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

CHECKED <i>KE</i>		APPROVED <i>KE</i>	DRAWING NO. D2432	REV. F
DATE 98.05.12			TITLE BEARPAW	SCALE 1:6
A		95.10.31	NEW ISSUE	
B		96.01.24	RE-DESIGN	
C		96.03.26	CHANGE BORE AND C'BORE DEPTH	
D		96.06.04	MOVE SLOT	
E		97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS	
F		98.05.12	CHANGE C'BORE, ADD B AND F P/N	

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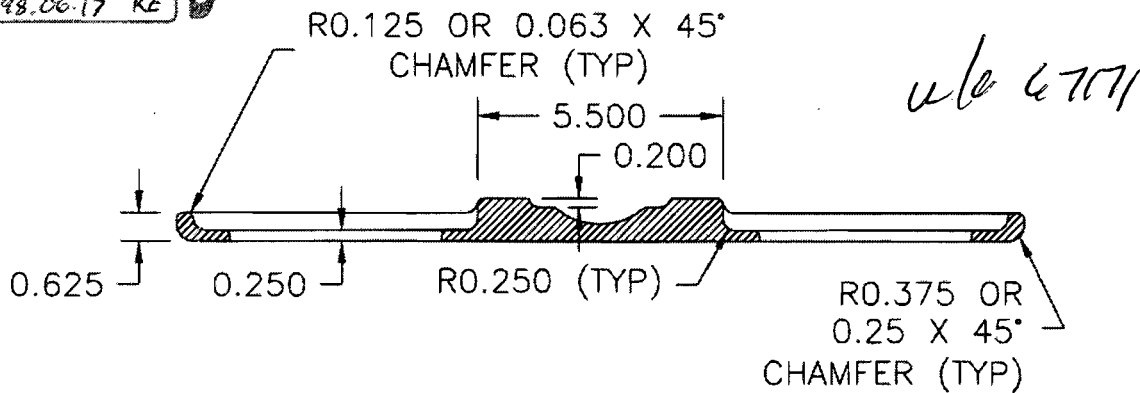
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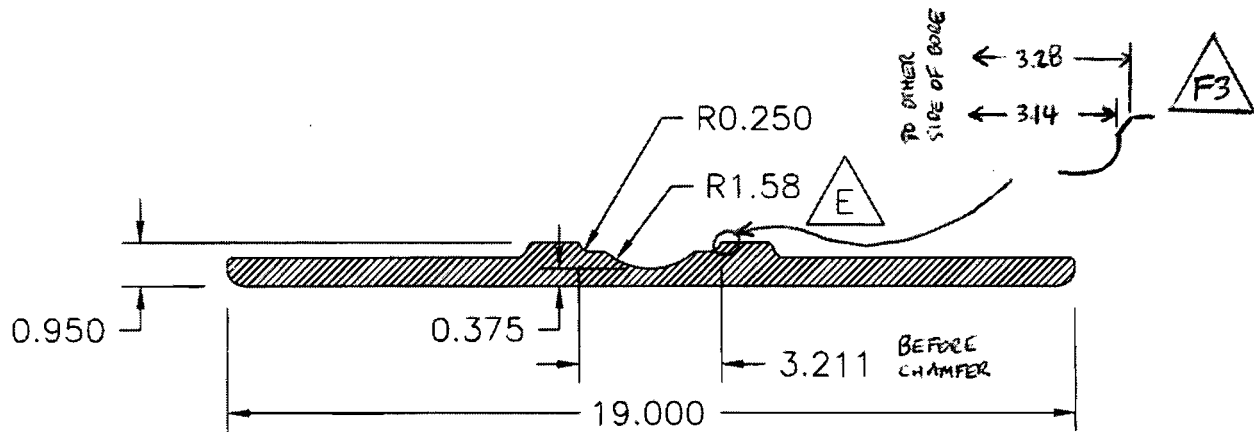


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED mg	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

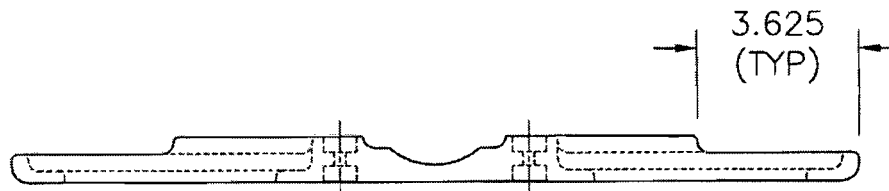
RELEASED
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

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